

Work Order ID 72952

Monday, August 22, 2011 7:03:30 AM



Page 1

Item ID: D2888

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 8/22/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 8/30/2011 Req'd Qty: 10.00



Customer:

Reference:

11-08-22

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2888	Rev A2

100

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blanks at 4.200" long
Grain along 4.200"*

11-08-23

10

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio D2888
Folio Rev: *AA*
Dwg Rev: *A*

11-08-25

10

2-Deburr

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Page 2

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Cust Item ID:

Required Date: 8/30/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	SHANK	11/08/26		10	0		
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	B.A	11/08/29		10	0		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							10x0 MP 11/08/29

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8=10
320
8=40

0.00

10x 4 M 11/08/30

160

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

10 4 M 11/08/30

170

Identify as per dwg & Stock Location:

0.00



Packaging

Packaging

Memo

0.00

411/8/31 (10)

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Accept



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Start Date: 8/22/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 8/30/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/31

MF

11-08-31

Picklist Print

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Page 1

Work Order ID: 72952



Parent Item: D2888



Parent Item Name: Lug

Start Date: 8/22/2011

Required Date: 8/30/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP C00.06.22 Removed P/O for powder coat EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.500X03.50 0		Purchased	No			100	f	13.6000	0.39	3.9			



SL 11-08-23

6061-T6 Bar 2.50 x 3.50

Location

Loc Qty

Loc Code

MAT008

13.6

113403

1.6

118071

12

4.0 ft

DART AEROSPACE LTD		Work Order:	72952
Description: Lug		Part Number:	D2888
Inspection Dwg: D2888 Rev: A2		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.386	+0.005/-0.000	.388	✓		Vern. J3	
Ø0.88	+/-0.030	.878	✓			
0.063 x 45°	+/-0.010	.06 x 45°	✓			
4.06	+/-0.030	4.061	✓		H-G	
Ø0.760	+0.005/-0.000	.760	✓		Vern. J3	
3.48	+/-0.030	3.480	✓			
2.500	+/-0.010	2.500	✓			
2.75	+/-0.030	2.760	✓			
0.438	+/-0.010	.436	✓			
0.080 x 45°	+/-0.010	.09 x 45°	✓			
1.85	+/-0.030	1.854	✓			
1.000	+/-0.010	1.001	✓			
0.425	+/-0.010	.426	✓			
0.030 x 45°	+/-0.010	.03 x 45°	✓			
1.875	+/-0.010	1.869	✓		H-G	
0.375	+/-0.010	.371	✓			
R0.25	+/-0.030	.250	✓			
1.29	+/-0.030	1.288	✓			
0.414	+/-0.010	.404	✓		H-G	
3.41	+/-0.030	3.412	✓			

Measured by:	JL
Date:	11-08-26

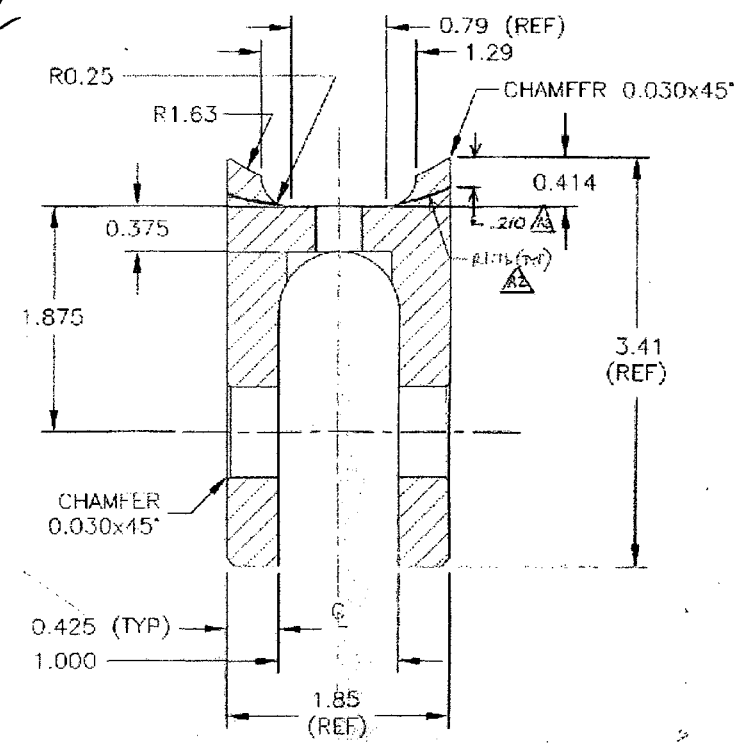
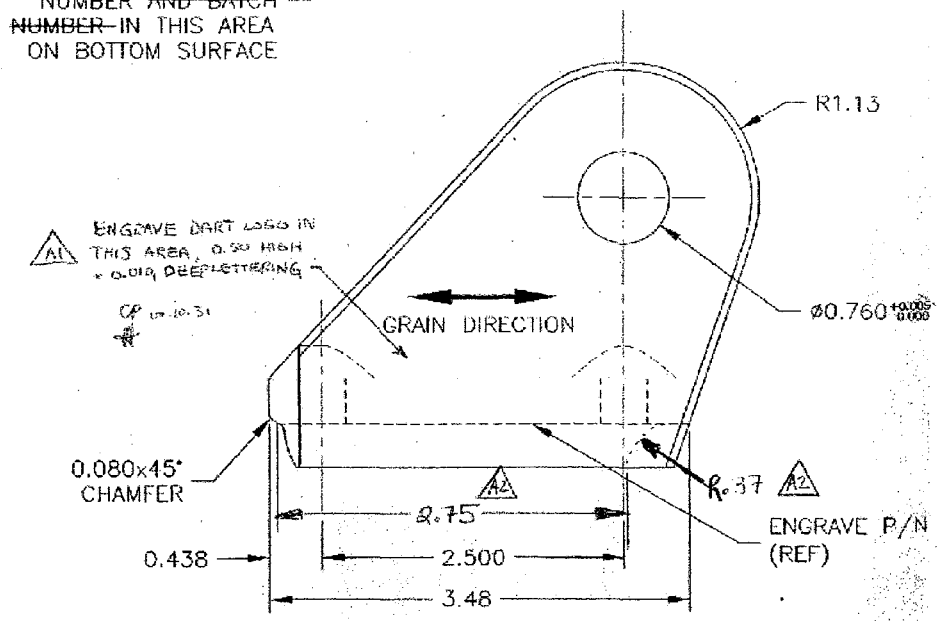
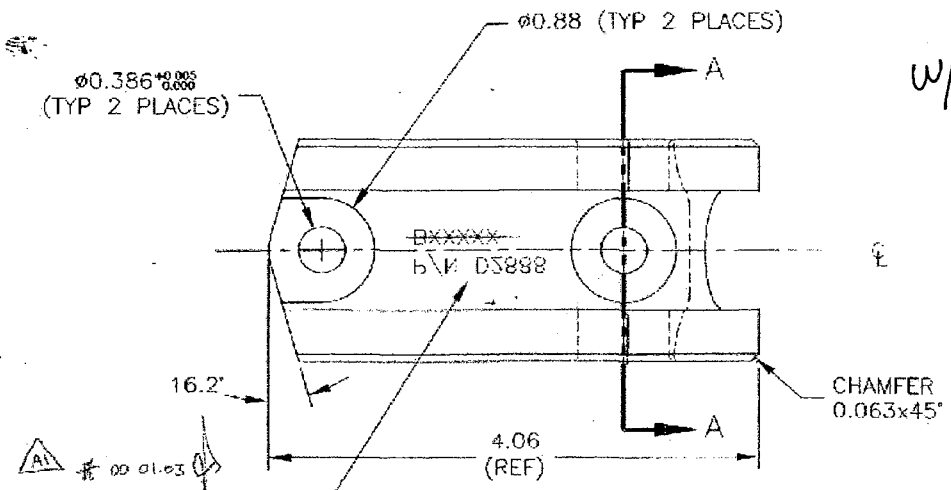
Audited by:	B.A
Date:	11/08/29

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.06.04	New Issue	KJ/DD	JD

1887

w/072952



SECTION A-A
SCALE 1:1

RELEASED
99.07.09 05

MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
BREAK UNMARKED EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

A		99.06.21	NEW ISSUE
DESIGN	BY	CP	DART DART AEROSPACE LTD MISSISSAUGA, ONTARIO, CANADA
CHECKED	APPROVED	AE	DRAWING NO. D2888
DATE	TITLE	LUG	REV. A SHEET 1 OF 1 SCALE 1:1
A2	01.04.01	Add Solder Cleanable for NCR 704	
A1	00.10.31	Update Engineering	
99.06.21			